Work Order ID 80052 *80052*

February-09-12 12:39:23 PM

Item ID: D2596 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID: **Stop** *NS2*

Item Name: Web, 205 Skidtube

Start Date: 09/02/2012 **Start Qty:** 2.00 *2*

Required Date: 23/02/2012 **Req'd Qty:** 2.00 *2*

Cust Item ID:

Customer:

Reference:

Approvals: **Process Plan:** M.L.J **Date:** 12/02/09 **Tooling:** **Date:** **Run Start** *NR1*

QC: **Date:** **SPC (Y/N):** **Date:** **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp

Draw Nbr	Revision Nbr
D2596	Rev D

100 *100* Skidtubes — Skidtubes — 0.00

Skidtubes

Memo 0.00

1- Cut D2500-3-100 to length: 99.5"
2- Use Jig DT8093 to drill pilot holes #30
3- Open to 0.630" diameter as per Dwg D2596
4- Deburr

110 *110* HandFinish — Chemical Conversion Coat per QSI005 4.1 — 0.00

Hand Finishing

Memo 0.00

12-02-10 12/02/10

120 *120* QC — QC5- Inspect part completeness to step on W/O — 0.00

Quality Control

Memo 0.00

DP 12-2-13

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ______

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Work Order ID 80052

February-09-12 12:39:23 PM

80052

Item ID: D2596 **Accept** *N900040100* **Setup Start** *NS1*

Revision ID:

Item Name: Web, 205 Skidtube **Stop** *NS2*

Start Date: 09/02/2012 **Start Qty:** 2.00 *2* **Cust Item ID:**

Required Date: 23/02/2012 **Req'd Qty:** 2.00 *2* **Customer:**

Reference:

Approvals: **Process Plan:** ________ **Date:** ________ **Tooling:** ________ **Date:** ________ **Run Start** *NR1*

QC: ________ **Date:** ________ **SPC (Y/N):** ________ **Date:** ________ **Stop** *NR2*

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Tool ID	Tool #	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
130 *130* Packaging Packaging	Identify as per dwg & Stock Location: 46	0.00	DP		12-2-13			2	
	Memo	0.00							
140 *140* QC Quality Control	QC21- Final Inspection - Work Order Release	0.00							
	Memo	0.00			MLJ	12/02/13			

12-02-13 (2)

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ **PAR #:** ______ **Fault Category:** ____________ **NCR:** Yes No **DQA:** _____ **Date:** ________

Resolution: ____________ **Disposition:** ____________ **QA: N/C Closed:** ________ **Date:** ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

Picklist Print

February-09-12 12:39:27 PM

1

Work Order ID: 80052

80052

Parent Item: D2596

D2596

Parent Item Name: Web, 205 Skidtube

Start Date: 09/02/2012 **Required Date:** 23/02/2012

Start Qty: 2.00 **Required Qty:** 2.00

Comments: IPP: D99.02.02Changed QA to QC, Added Step 6 and CostDM
IPP Rev:E 07-07-09 Incorperated DEO 9183 JLM

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Qty per Kit	Total Qty	Qty Issued	Date Issued	Status
D2500-3-100		Manufactured	No			100	Each	12.0000	1	2			
D2500-3-100 Ext'n -`I' Beam Web 4"									**		[signature]	12-02-09	

Location	Loc Qty	Loc Code	
LG	12		
51957	2		
66298	10		2

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ____________ PAR #: ______ Fault Category: ____________ NCR: Yes No DQA: _____ Date: ________

Resolution: ____________ Disposition: ____________ QA: N/C Closed: ________ Date: ________

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
			Corrective Action Section B					
DATE	STEP	Description of NC Section A	Initial Chief Eng	Action Description Chief Eng	Sign & Date	Verification Section C	Approval Chief Eng	Approval QC Inspector

NOTE: Date & initial all entries

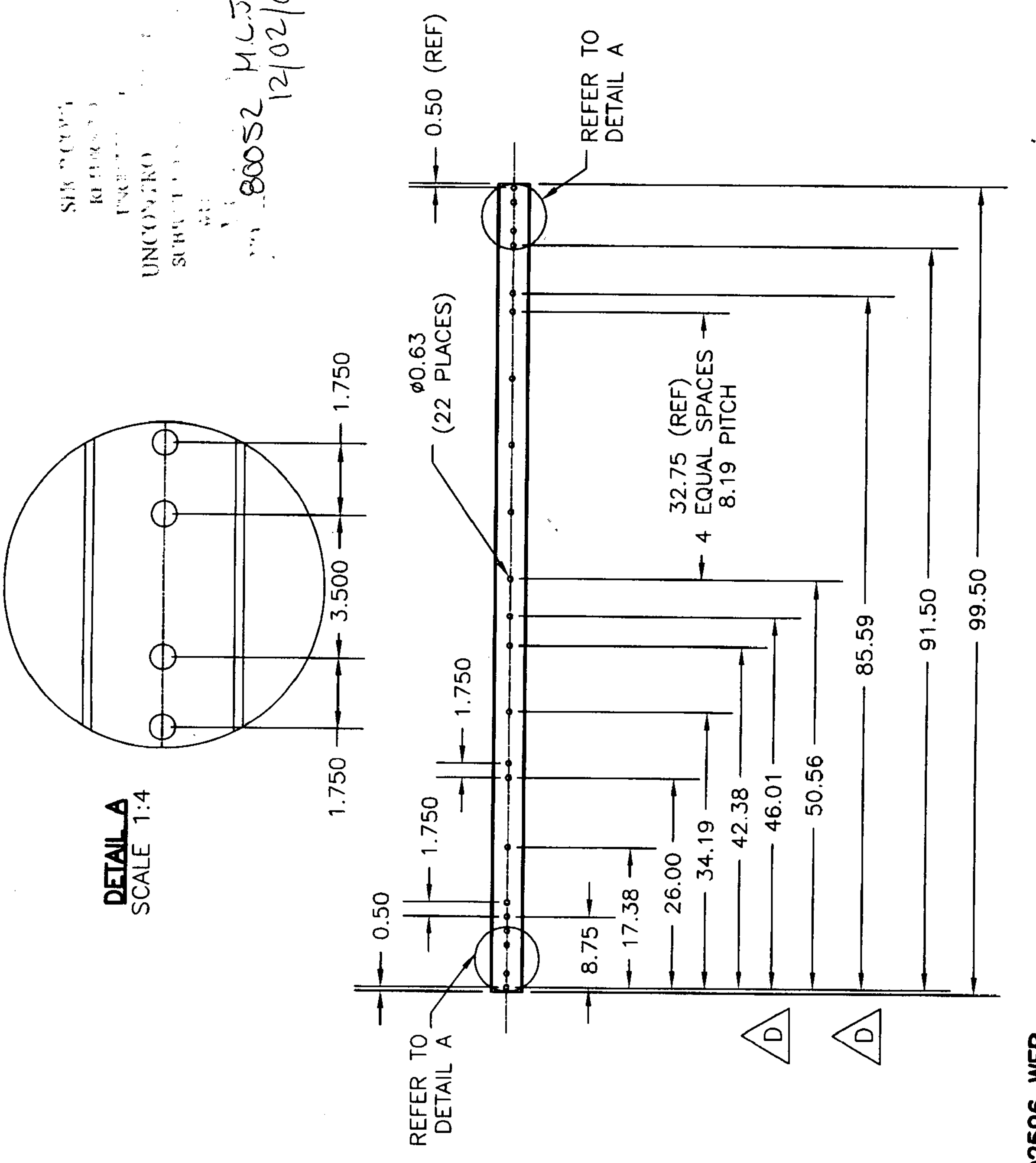
DART

DESIGN	DRAWN BY	DART AEROSPACE LTD HAWKESBURY, ONTARIO, CANADA
RH	RH	
CHECKED	APPROVED	DRAWING NO. D2596 — REV. D — SHEET 1 OF 1
DATE 07.04.17		TITLE 205 WEB — SCALE 1:20

REV	DATE	DESCRIPTION
A	96.09.16	NEW ISSUE
B	97.07.23	ø0.63 HOLE WAS ø0.56
C	98.09.14	INCORPORATED DEO 9097
D	07.04.17	INCORPORATED DEO 9183

RELEASED 07.06.28

80052 MCJ 12/02/09



D2596 WEB

1) MATERIAL: MAKE FROM D2500-3-100 EXTRUSION
2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
3) ALL DIMENSIONS ARE IN INCHES
4) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
5) DEBURR SHARP EDGES 0.010 TO 0.020

Dart Aerospace Ltd

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: ______________ **PAR #:** ______ **Fault Category:** ______________ **NCR:** Yes No **DQA:** _____ **Date:** _______

Resolution: ______________ **Disposition:** ______________ **QA: N/C Closed:** _______ **Date:** _______

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries